

Date: Wednesday, 3/26/2008 9:54:20 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : PLUG
Job Number : 38182	
Estimate Number : 12322	
P.O. Number :	Part Number : D3492041
This Issue : 3/26/2008 S.O. No. :	Drawing Number : D3492 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : C
Previous Run : 36902	Material :
Written By :	Due Date : 4/10/2008 Qty: 40 Um: Each
Checked & Approved By : <u>JTD 08.03.27</u>	
Comment : est rev A 06.03.03 New Issue EC	
Est Rev:B 06-08-28 As per Rev B JLM	
Est Rev:C 07-12-06 Rev C dwg DD	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6R0625	6061-T6 Round Bar .625"
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Comment: Qty.: 0.0656 f(s)/Unit Total : 2.6250 f(s)  
 6061-T6 Round Bar .625"  
 (M6061T6R0625)  
 Batch: MP07513

(40)

MMF 08/04/13

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
-----	----------	--------------------------



Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA633 &amp; Dwg D3492

Dwg Rev: BFolio Rev: AAMMF 08/04/13

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

Comment: INSPECT PARTS AS THEY COME OFF MACHINE MMF 08/04/13

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

MMF 08.04.13

(40)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

1-Deburr if necesay

N/A 08.04.19

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 3/26/2008 9:54:21 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLUG

Job Number: 38182

Part Number: D3492041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(40)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BR 08-04-21

1388182  
03492041  
29/04/2008

7.0

POWDER COATING

POWDER COATING



M107550

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3  
(Flat End Only)

BR 08-04-21

S.142 10.17  
#1 319.3 F  
#2 300.1 F  
#3 --- F  
#4 --- F

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 08-04-29 (40)

9.0

NAS1611010

O-RING



Comment: Qty.: 1.0000 Each(s)/Unit Total : 40.0000 Each(s)

Qty Part Number Description Batch

1 NAS1611-010 O-RING

✓ (or MS28775-010)

M100359 BR/RB 08-05-01

(40)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Hand Finishing

1- Assemble O'Ring as per Dwg D3492 Applying some O'Ring Lube

A/R 55-O'Ring Lube Batch:

M101223 BR/RB 08-05-01

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

cont  
2005/7 (40)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



F-P-1

Comment: PACKAGING RESOURCE #1

M-F 08/05/01

(40X)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/05 (40)

Job Completion



M-F 08-05-02

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

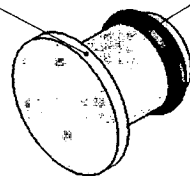
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3492-XX PLUG  
(SEE TABLE)

NAS1611 PLUG  
(SEE TABLE)



### D3492-XXX PLUG PARTS LIST

QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -053	PART NUMBER	DESCRIPTION
X							D3492-041	PLUG ASSEMBLY
	X						D3492-043	PLUG ASSEMBLY
		X					D3492-045	PLUG ASSEMBLY
			X				D3492-047	PLUG ASSEMBLY
				X			D3492-049	PLUG ASSEMBLY
					X		D3492-051	PLUG ASSEMBLY
						X	D3492-053	PLUG ASSEMBLY
1							D3492-1	PLUG
	1						D3492-3	PLUG
		1					D3492-5	PLUG
			1				D3492-7	PLUG
				1			D3492-9	PLUG
					1		D3492-11	PLUG
						1	D3492-13	PLUG
		1					NAS1611-005	O-RING
			1				NAS1611-007	O-RING
1							NAS1611-010	O-RING
						1	NAS1611-012	O-RING
	1						NAS1611-013	O-RING
					1		NAS1611-015	O-RING
				1			NAS1611-016	O-RING

△ △ △

#### NOTES:

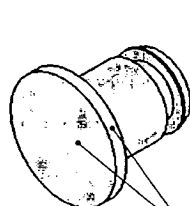
1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX

RELEASED  
07.10.05

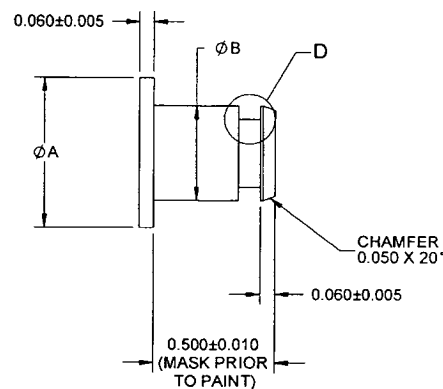
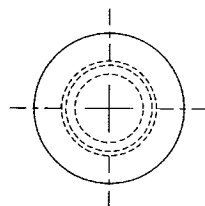
C	ADD -049/-051/-053, CHANGE DRAWING FORMAT	PH	07.10.05
B	ADD -047; UPDATE DIM A FOR -045	PH	06.05.11
A	NEW ISSUE	PH	06.01.04
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.10.05		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. C	
DRAWING NO. D3492		SHEET 1 OF 2	
TITLE PLUG		SCALE 2:1	
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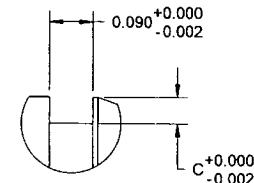




POWDER COAT THESE  
FACES ONLY PER NOTE 2



**D3492-XX PLUG**



**DETAIL D**

**D3492-XX PLUG MACHINING DETAILS**

P/N	A	B	C	MATERIAL SPEC
D3492-1	0.625	0.394	0.055	M6061T6R0.625
D3492-3	0.750	0.582	0.045	M6061T6R0.750
D3492-5	0.375	0.188	0.045	M6061T6R0.375
D3492-7	0.500	0.270	0.045	M6061T6R0.500
D3492-9	0.938	0.750	0.045	M6061T6R1.000
D3492-11	0.850	0.664	0.045	M6061T6R0.875
D3492-13	0.750	0.520	0.045	M6061T6R0.750

**NOTES:**

- 1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6R0.000)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

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07.11.16

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		<b>D3492</b>	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		<b>PLUG</b>	4:1
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